

Date: Thursday, 18/06/2009 7:32:52 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LATCH BRACKET
 Job Number : 48648
 Estimate Number : 10994
 P.O. Number :
 This Issue : 18/06/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D2583
 Drawing Number : D2583 REV. B
 Project Number : N/A
 First Issue : / / Type : SMALL / MED FAB Drawing Revision : B
 Previous Run : 46164 Material :
 Due Date : 24/06/2009 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : CY09/06/18
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat- in house
 processDM
 Est: D 06.07.21 Waterjet EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.1227 sf(s)/Unit Total: 4.9098 sf(s)
 Material: 5052-H32 (QQ-A-250/8) 0.040" thick
 (M5052H32S040) Batch: 109058X3 B9-6-18

104921 x 7

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2583
 Dwg Rev: B B9-6-18
 Prog Rev: B

(44)

2-Deburr if necessary B9-6-18

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B9-6-18

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

509/06/19
 counter
 (44)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Deburr
 Form on CNC Brake as per Dwg D2583

509/06/22 (44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 18/06/2009 7:32:52 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 48648

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



S 09/06/22

counts
(44)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



UMP 09/06/22

(44)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



M 11/04/22

START TIME:

3:30pm

OVEN TEMPERATURE:

320°C

FINISH TIME:

4:00pm

all

09-06-22

(44)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



M-L 09/06/22

(44)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

36



R 09/06/23

(44)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



09/06/23

Job Completion



mf 09-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48648
Description: Latch Bracket	Part Number:	D2583
Inspection Dwg: D2583 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST


x

First Article

Prototype

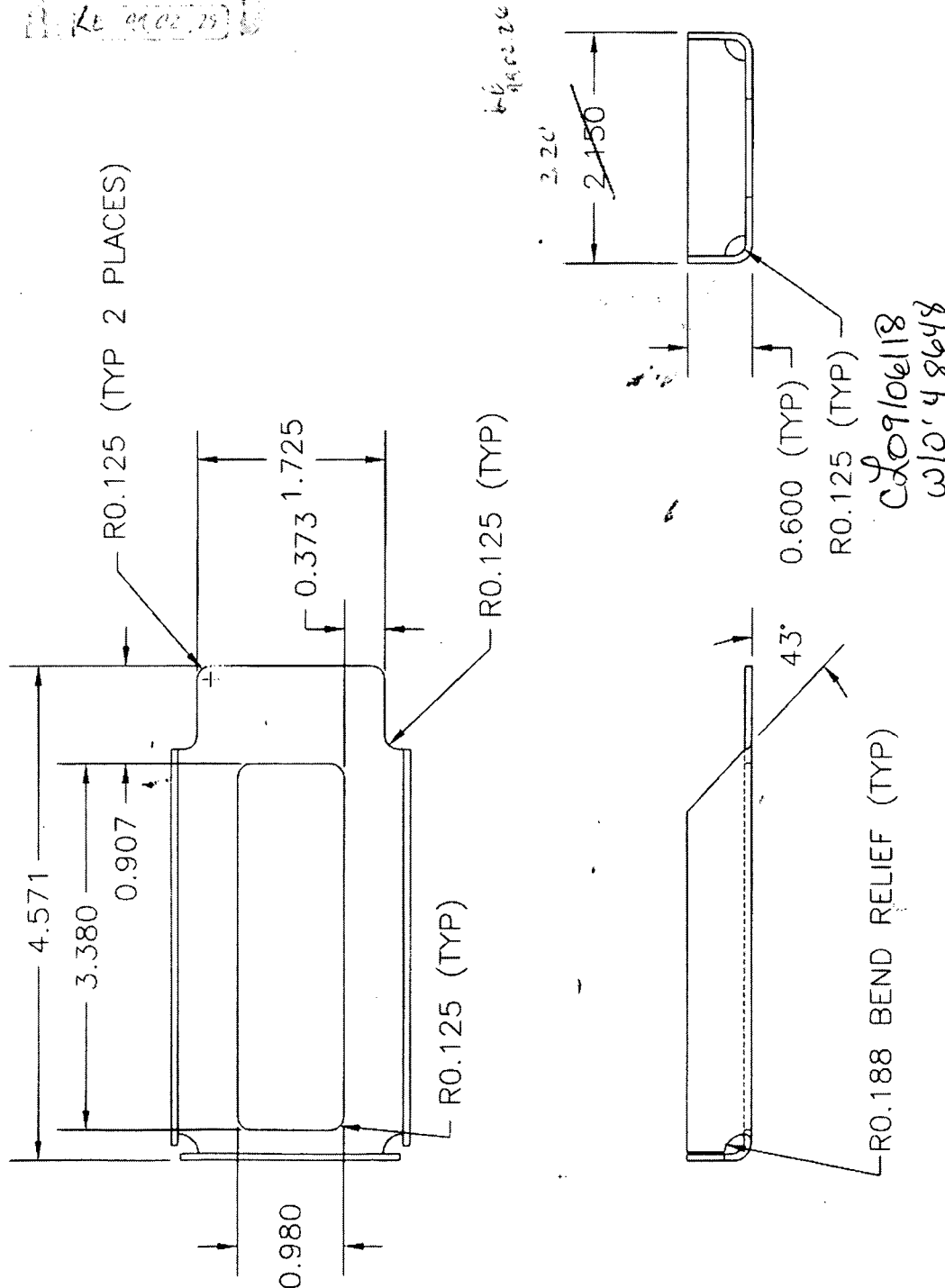
[illegible]

Measured by: <u>UB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-6-18</u>	Date: <u>02/06/19</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	



DESIGN MIKE M.	DRAWN BY RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P	APPROVED KE	DRAWING NO. D2583	REV. B SHEET 1 OF 1
DATE 99.02.22		TITLE LATCH BRACKET	SCALE 2:3
A	96.07.10	NEW ISSUE	
B	99.02.22	CHANGE OF FINISH (PER TSR A887)	



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries